

**KANEPACKAGE PHILIPPINE INC.**

No. 5 Ring Road LISP II, Brgy. La Mesa, Calamba City, Laguna

Telephone No. (049) 545-7166 to 69

Fax No. (049) 545-6302

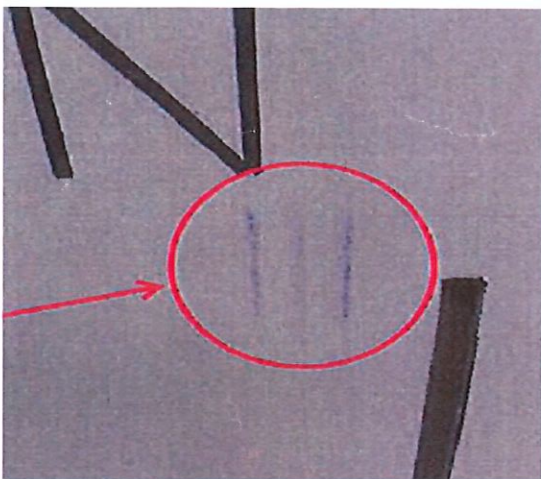
INVESTIGATION REPORT FORM (IRF)☒ Inhouse Detection☐ Customer Claim

Control No.: 602

Date Issued: 22 07 25

Customer	BIPH	Attention To	Gerald De Guzman
Item Code	D01XJN001	Department	Production
Item Description	CARTON BOX	Date of Detection	22 07 22
Job Order Number	JO22-M-00847-12	Section Detected	QA-SCREENING

ILLUSTRATION OF THE PROBLEM

☒ Major☐ Minor

Lot Quantity (pcs.)

Reject Quantity (pcs.)

Reject Percentage

15,000

258

1.72%

Nature of Defect:

INK STAIN

Requirement:

No ink stain

Actual:

occurrence of ink stain

NO. OF OCCURRENCE	DISPOSITION	AREA OF OCCURRENCE / ORIGIN		CONTENT
<input checked="" type="checkbox"/> First	<input type="checkbox"/> Hold	<input type="checkbox"/> Slotter	<input type="checkbox"/> Gluing	<input type="checkbox"/> Material
<input type="checkbox"/> Recurrence	<input type="checkbox"/> Special Acceptance	<input checked="" type="checkbox"/> EQOS	<input type="checkbox"/> Vertical	<input type="checkbox"/> Dimension
No.: _____	<input checked="" type="checkbox"/> For Rework	<input type="checkbox"/> Diecut	<input type="checkbox"/> Others:	<input checked="" type="checkbox"/> Appearance
Date: _____	<input type="checkbox"/> Reject / Disposal	<input type="checkbox"/> Detaching		<input type="checkbox"/> Process / Method
Issued by	Checked by	Approved by	Received by (Receiving Section)	
 Rochelle Evangelista QA-IE Staff	 Roderick Ramos QA Sr. Supervisor	 Rexel Almario QA Asst. Manager	 Gerald De Guzman Head/Supervisor	

I. INVESTIGATION / ANALYSIS

DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)

INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)

System / Training	Why 1:	N/A	Why 1:	N/A
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Design / Toolings	Why 1:	N/A	Why 1:	N/A
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	
Process / Material	Why 1:	PLS- SEE ATTACHED	Why 1:	PLS- SEE ATTACHED
	Why 2:		Why 2:	
	Why 3:		Why 3:	
	Why 4:		Why 4:	
	Why 5:		Why 5:	

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INVESTIGATION REPORT FORM (IRF)**FINAL CONCLUSION****OCCURRENCE ROOTCAUSE****OUTFLOW ROOTCAUSE**

-THE INK STAIN IN THE CYREL
TRANSFER IN CORRUGATED BOARD
DURING MASS PRODUCTION

MINIMAL INK STAIN

IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)

CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)

A. Sorting Result**Actions to be done to eliminate recurrence****Who / When**

	Location	Total Stock	NG	Total Good
RM				
WIP				
FG				

System	N/A	
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B. Orientation

Date		Time	
Title			
Attendees			

Design / Tools	N/A	
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C. Reworking

Rework Quantity	
Total Good	
Rework Percentage (Good)	

Process	PLS. SEE ATTACHED	
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II. QA ROOTCAUSE VERIFICATION (To be filled out by QA In-charge)

Date Conducted: 7/29/22 PIC: DA IE

Identified Rootcause**Recommendation**

Ink stain in the cyrel transfer
in corrugated board

N/A

III. CORRECTIVE ACTION VERIFICATION (To be filled out by QA In-charge)

	Checked by	Date	Implemented?	Remarks
1st Verification of Action	DA IE	7/29/22	[X] Yes [] No	N/A
2nd Verification of Action			[] Yes [] No	
3rd Verification of Action			[] Yes [] No	
Effectiveness of Action			[] Yes [] No	

Note: If no same defects / problems occurs for 5 consecutive deliveries, corrective action is considered effective / closed. If the same problem occurs within 5 consecutive deliveries or 3rd verification of action still not yet implemented, Investigation Report shall be re-issued to the affected department to provide new improvement action.

QUALITY ASSURANCE DEPARTMENT

IV. CLOSURE

CLOSED 230105	Remarks:	Approved by:	Process Owner Acknowledgment: (Receiving Section)	
		QA Supervisor	QA Asst. Manager	
	Date:	Date:	Date:	Date:

INVESTIGATION REPORT FOR BROTHER D01XJN001 CARTON BOX INK STAIN

DIRECT CAUSE PROCESS/MATERIAL	W1	There is a factor that due to sudden cleaning of cyrel since this item have critical print with big quantity to be process the part of cyrel clean enough when they proceed again to mass production.
	W2	The ink stain in the cyrel transfer in corrugated board during mass production that caused this issue.

INDIRECT CAUSE (OUTFLOW) PROCESS/MATERIAL	W1	Operator didn't notice the ink stain since the ink stain is very minimal together with the machine speed of 90bpm skip On mode.
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PRODUCTION CORRECTIVE ACTION

1. Rework the effected since the ink stain are minimal and reworkable.
2. Orient the operator regarding this issue and told them to clean well and dry the cyrel before back and proceed to mass production.

PIC:	PRODUCTION	TARGET DATE:	220729
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PREPARED BY:

220727
GERALD DE GUZMAN
PROD ASST. SUPERVISOR

APPROVED BY:

Paul
WEENA V. APALLA
ASST. MANAGER